

Work Order ID 69266

Friday, May 06, 2011 8:51:20 AM



Page 1

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 5/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

(2)

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

SAD 11-05-09

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: *115928*

6- grind weld flush where indicated on dwg

11-05-24

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11-05-25 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69266

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Page 2

Item ID: D3836-041

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

8 11/05/24



QC

Memo

0.00

Quality Control

(X)

11-05-24

150

Identify as per dwg & Stock Location: WA

0.00

3AD



Packaging

Memo

0.00

Packaging

11-05-25

(2)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/26

CL 11/05/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

Friday, May 06, 2011 8:51:26 AM

Page 1

Work Order ID: 69266

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 5/6/2011




Required Date: 5/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3 		Manufactured	No			100	Each	0.0000	1	2			
Spacer Bushing M304TS0.750W.065 		Purchased	No			100	f	1,447.586	1.7808	3.749053			
304 SQ Tube .75x.75x.065W 													

Location	Loc Qty	Loc Code
MAT018	1000	
117598	1000	
WA007	447.5859906	
116267	179.684072	
116763	267.901919	

3.7491

369436 → @ 11-05-09
SAD 11-05-09

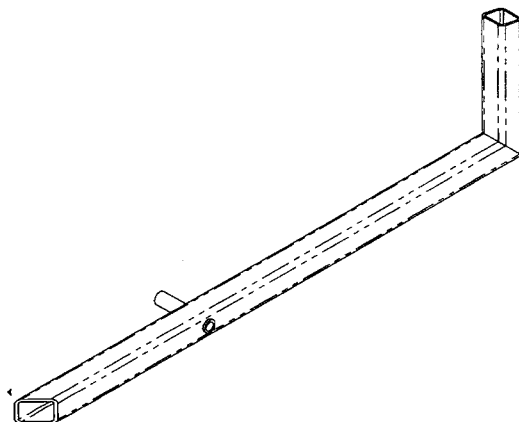
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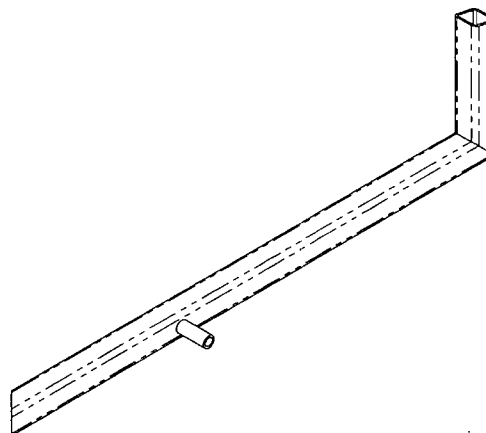
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NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SPOT CHECK
 FEATURES:
 FINISH: NONE
UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *69266*

pl 11-05-6

RELEASED
08/11/24 MP

A	NEW ISSUE	DESCRIPTION	MB	08.09.24
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.24			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3836	SHEET 1 OF 3
TITLE	RIB ASSY (BASKET LID)	SCALE
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W/O:		WORK ORDER CHANGES						
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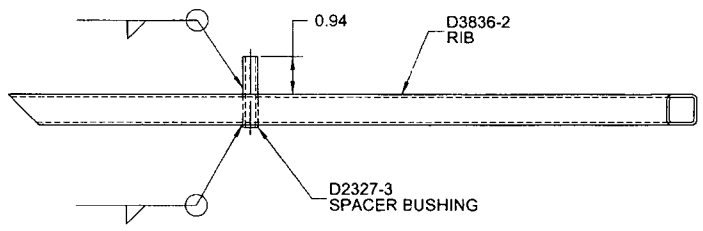
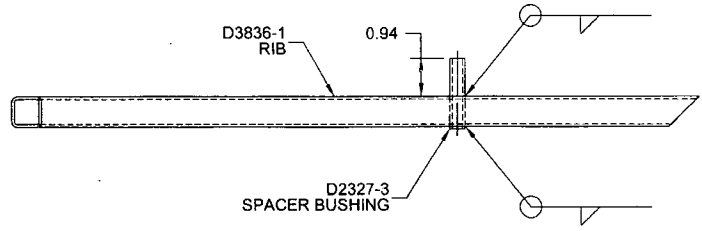
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

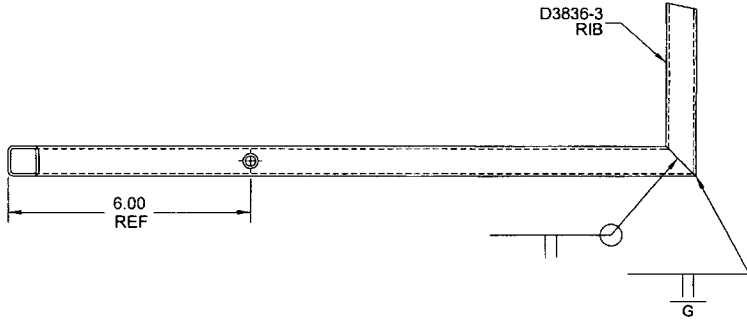
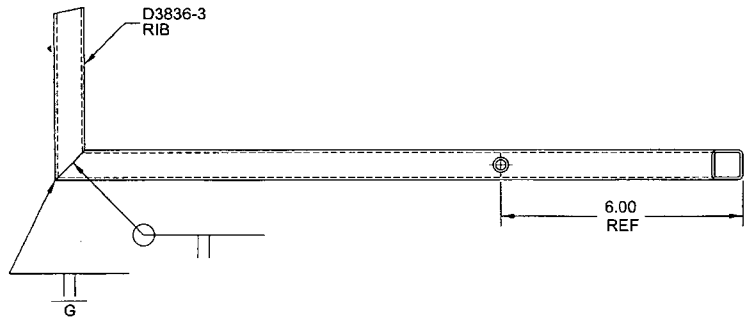
D

D



C

C



B

B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

aw 69266

RELEASED
08/11/18 MJP

A

A

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

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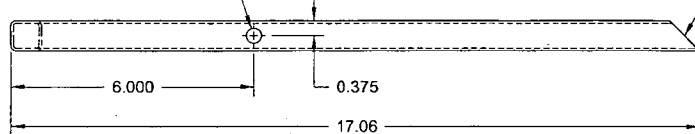
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0.75 X 45°
CHAMFER

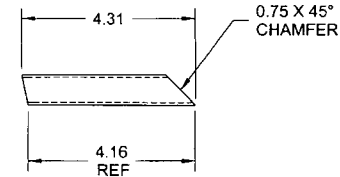


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



0.75 X 45°
CHAMFER

D3836-1 RIB

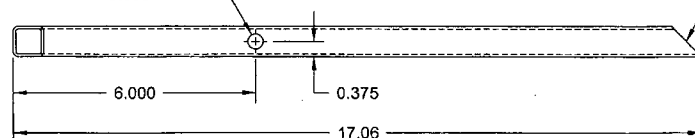


D3836-3 RIB

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CHAMFER

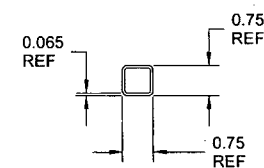


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



0.75 X 45°
CHAMFER

D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1-2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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